Page 1

Item ID:

Tuesday, June 28, 2011 10:15:07 AM

Accept

Setup Start

Stop



Revision ID:

Item Name:

Fwd Tube Assembly

Start Date: 6/28/2011

D3391-021

Start Qty: 1.00

Required Date: 7/27/2011 Req'd Qty: 1.00



Date: _____

Cust Item ID:

Customer:

Reference:

Approvals: QC:

Date: 1-06-28 Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Sequence ID/ Work Center ID

Operation Description Set Up/ **Run Hours** Tool ID

Tool # Plan

Accept Code Qty

Reject Qty

Reject Number

Insp. Stamo

Draw Nbr

Revision Nbr

Rev H

D3391

100

Skidtubes

Skidtubes

Memo

0.00

0.00

Skidtubes

Cut extrusion to 46.52 +0.010 -0.020

110

CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

0.00

0.00

Bend as per Dwg D3391 Using Bend Prog 3391021

120

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

Dait Aci	ospace	5 LIU									
W/O:			V	VORK ORDER CH	ANGES			-			
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Ca	tegory:	NC	R: Yes 1	No DQ	A: Date:			
	R	esolution:	Disposit	ion:	QA: N/C Closed: Date:						
NCR:		\	VORK OR	DER NON-CONFO	DRMANCE	(NCR))				
DATE	STEP	Description of NC		Section B		Verific	cation	Approval	Approval		
DAIL	JILF	Section A	Initial Chief Eng	Action Descrip Chief Eng	ption 	Sign & Date	Secti		Chief Eng	QC Inspector	
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Tuesday, June 28, 2011 10:15:07 AM

Page 2

Item ID:

D3391-021

Accept

Setup Start

Stop



Revision ID:

Item Name:

Fwd Tube Assembly

Start Date:

Required Date: 7/27/2011

6/28/2011

QC:

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Tool # Plan

Code

Run

Start

Reject

Stop

Reject

Qty

Number Stamp

Insp.

Sequence ID/ Work Center ID

130

HAAS 1

HAAS CNC vertical machine #1

Operation Description

HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA590 Rev. AA & Dwg D3391 Rev.

Date:

0.00

0.00

Tool ID

Accept

Qty

140

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Identify as D3391-1 2-Deburr

0.00

0.00

150

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

Memo

0.00

Drill X1 Aft cap as per Dwg D3391 .1875" dia

\$ 11/06/29

		— - -														
W/O:			WORK ORDER CHANGES													
DATE	STEP	PROC	EDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector							
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Part No		PAR #:														
		esolution:	_ Disposit	ion:	_ QA: N/C	Closed:		Date: _								
NCR:	-	W	ORK OR	DER NON-CONFORMA	NCE (NC	R)										
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	Sign	& Sect	cation ion C	Approval Chief Eng	Approval QC Inspector							
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Work Order ID 71329

Tuesday, June 28, 2011 10:15:07 AM



Page 3

Item ID:

D3391-021

Accept

Setup Start

Stop



Revision ID:

Item Name:

Fwd Tube Assembly

Start Date:

6/28/2011

Start Qty: 1.00

Required Date: 7/27/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Tooling: Date: _____

Date:

Date:

Run

Code

Stop

Start



Sequence ID/

Work Center ID

Date:_

SPC (Y/N):

0.00

0.00

Tool ID

Tool # Plan

Accept Qty

Reject Qty

Reject Insp.

160

Quality Control

Operation Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/ Run Hours

11/06/29

Stamp Number

170

Quality Control

QC8- Inspect parts - second check

Memo

0.00

Memo

0.00

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DATE	STEP	PROC	EDURE CH	IANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	_ Fault Ca	tegory: 🤼		_ ÑC	R: Yes	lo DQA		Ďate:	<u> </u>
-	R	esolution:	_ Disposit	ion:	•	QA	: N/C Clo	sed:		Date: _	· · · · · · · · · · · · · · · · · · ·
NCR:	_j a	We	ORK OR	DER NO	N-CONFORMA	NCE	(NCR)		- -		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Act	/e Action Section ion Description Chief Eng	on B	Sign &	Verifica Section		Approval Chief Eng	Approval - QC Inspector
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NOTE: Da	ate & initi	al all entries					* /*				

Page 4

Tuesday, June 28, 2011 10:15:07 AM Item ID: D3391-021 Accept Setup Start Revision ID: Stop Fwd Tube Assembly Item Name: Start Qty: 1.00 **Start Date:** 6/28/2011 Cust Item ID: Required Date: 7/27/2011 **Req'd Qty:** 1.00 **Customer:** Reference: Start Run Date: Approvals: Process Plan: Tooling: Date: Stop Date: _____ SPC (Y/N): Date: Sequence ID/ Operation **Tool ID** Tool # Plan Set Up/ Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code **Qty Qty** Number Stamp 180 0.00 Skidtubes 0.00 Memo kidtubes 1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size) (ONLY DRILL HOLES MARKED "A") 2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step 3-Open tow cap holes to .208" as per Dwg D3391 4-Open Tow Ring hole to .640" as per Dwg D3391 11/06/30 5- open float bag holes 0.328" and counter sink as per dwg D3391 6-Deburr & Scribe Batch number Inside aft end. 7-Transfer drill D3391-021 with D3391-023 QC5- Inspect part completeness to step on W/O QC

Quality Control

Memo

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W/O:			W	ORK ORDER CHANGE	S		,	-		
DATE	STEP	PRO	CEDURE CH	ANGE	***	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:		·						
	R	esolution:	Disposit	ion:	QA	N/C Clo	sed:		Date: _	
NCR:		V		DER NON-CONFORMA	. Ş	(NCR)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	n B	Sign & Date		cation ion C	Approval Chief Eng	Approval QC Inspector
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Work Order ID 71329

Tuesday, June 28, 2011 10:15:07 AM



Page 5

Item ID:

D3391-021

Accept



Setup Start

Stop



Revision ID:

Item Name:

Required Date: 7/27/2011

Fwd Tube Assembly

Start Date:

6/28/2011

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date: _____

Tooling:

SPC (Y/N):

Date:

Tool ID

Date:

Run

Start

Stop



Sequence ID/ Work Center ID

200

Hand Finishing

Operation Description

Chemical Conversion Coat per OSI005 4.1

Set Up/ **Run Hours**

0.00

Tool # Plan Code Accept Qty

Reject Qty

Reject Number Stamp

Insp.

HandFinish

Memo

0.00

0 SAN 11-06-30

210

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

220

Skidtubes

Skidtubes

Skidtubes

Memo

1-instal spacers as per dwg D3391

A/R Magnabond 6398 batch: 1 exp. date: ///08/cure time 12hrs. as per QSI015

2- grind crossbolt flush 3-back drill crossbolt if necessary

0.00

0.00

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W/O:			WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A :	Date: _						
	R	esolution:	Disposition	n:	QA: N/C Closed: Date:									
NCR:		•	WORK ORD	ER NON-CONFORMA	NCE (NCR)								
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval					
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector					
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Work Order ID 71329

Tuesday, June 28, 2011 10:15:07 AM



Page 6

Item ID:

D3391-021

Accept



Setup Start

Stop



Revision ID:

Item Name:

Fwd Tube Assembly

Start Date:

6/28/2011

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

Required Date: 7/27/2011

QC:

Date: _____

SPC (Y/N):

Tool ID

Date:

Tool # Plan

Code

Accept Oty

Reject Oty

Reject Number Stamp

Insp.

Sequence ID/ Work Center ID

230

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

poleshu 8 000

Memo

235

HandFinish

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

Hand Finishing

AND REALODINE AS PER PAR09-043

240

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

1X 8 m/ 4/57/x

15- Bl 11-7-4.

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W/O:			WORK ORDER CHANGES											
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
 														
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	_ Date: _								
	R	esolution:	Dispositi	on:	QA: N/C C	losed:		Date: _						
NCR:		V	VORK ORI	DER NON-CONFORMA	NCE (NCI	₹)								
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval					
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Work Order ID 71329

Tuesday, June 28, 2011 10:15:07 AM



Page 7

Item ID:

D3391-021

Accept

Setup Start

Stop



Revision ID:

Item Name:

Fwd Tube Assembly

Start Date:

6/28/2011

Start Qty: 1.00

Required Date: 7/27/2011

QC:

Req'd Qty: 1.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



Date: _____

SPC (Y/N):

Set Up/

Run Hours

Date: _

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

Sequence ID/ Work Center ID

250

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

0.00

0.00

0.00

0.00

255

Skidtubes

Skidtubes

Skidtubes

Memo

**** install D3591-1 spacer as per DSI9364 and wearplate and gasket as per

DWG ****

257

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

1.1

		— - 									
W/O:		· ·	W	ORK ORDER CHANG	ES				······································		
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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	R	esolution:	Disposition: QA: N/C Closed: Da								
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DATE	STEP	Description of NC		Corrective Action Secti		Verifi	cation	Approval	Approval		
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Work Order ID 71329

Tuesday, June 28, 2011 10:15:07 AM



Page 8

Item ID:

D3391-021

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Required Date: 7/27/2011

Fwd Tube Assembly

Start Qty: 1.00 6/28/2011

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID

Operation Description

Identify as per dwg & Stock Location:

Set Up/ Run Hours Tool ID

Tool # Plan Qty Code

Reject Accept Qty

Reject Number

Insp. Stamp

260

Packaging

Memo

Memo

0.00 0.00 .7112-043/B71312

Packaging

280

QC21- Final Inspection - Work Order Release

0.00

0.00

Quality Control

W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	C	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Picklist Print

Work Order ID: 71329

Parent Item:

Parent Item Name: Fwd Tube Assembly

Start Date: 6/28/2011

Start Qty: 1.00

Required Date: 7/27/2011

Page 1

Required Qty: 1.00

Comments:

IPP A□05.09.13□New issue□

KJ/JLM□

IPP B□06.02.10□Dwg rev.D ecn 773 □EC□

IPP C□06.05.02□Added inspections □EC□

IPP D 07.03.13 rev F dwg

EC

IPP E 07.11.07 revG dwg ecn1053P

EC verified by: DD

IPP Rev:f ECN 1056 07-11-12 DD verified by: EC

IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC

IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC

IPP Rev J 09.02.02 added hardware EC verifified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seg ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6013-047		Manufactured	No			100	Each	18.0000		1			
Skidtube Material				Location LG	26547	<u>Loc (</u>	Otv 18 18	Loc Code		\mathcal{Y}	//-	6-6	28
D3670-4-200		Manufactured	No		20347	220	Each	38.0000	4	4 ·	-		Dh
STACER				<u>Location</u> LG		<u>Loc (</u>	<u>Oty</u> 38	Loc Code					11/06/
D3401-041 Tow Cap Assembly		Manufactured	No	•	10822	255	38 Each	2.0000		4 1 H	<u>ulo 3</u>	HOC	
				Location FP007	61505	<u>Loc (</u>	-	Loc Code B713	52 -	X \	- -		

Tuesday, June 28, 2011 10:15:04 AM

D3391-021

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W/O:			W	ORK ORDER CHANG	GES		· · · · · · · · · · · · · · · · · · ·						
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						<u> </u>							
Part No	:	PAR #:	Fault Cat	A:	Date:								
	R	esolution:	Disposition: QA: N/C Closed: Date:										
NCR:		1	WORK OR	DER NON-CONFORM	IANCE (N	CR)	•						
DATE	STEP	Description of NC			ction B		Verific	ation	Approval	Approval			
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Tuesday, June 28, 2011 10:15:04 AM

Work Order ID: 71329									
Parent Item: D3391-021									
Parent Item Name: Fwd Tube Assem	bly	11481114 11	***	E1 #1 188		St	tart Date: 6	5/28/2011	Required Date: 7/27/2011
							Start Qty: 1		Required Qty: 1.00
D3564-13	Manufactured	No		255	Each	16.0000	1	1	
Wearshoe						10.000		<u> </u>	20/700
			Location	Loc	<u>Oty</u>	Loc Code			
			FP016		16				_
			69280		16			<u> </u>	
D3566-13	Manufactured	No		255	Each	26.0000	1	1	
								H	0 0/F0/n
			Location	Loc	Oty	Loc Code			
			FP		24				
			<u>6928</u> 1		24				_
			FP014		2				_
			68341		2				_
AN960C10L NAS1149C033	² Purchased	No		255	Each	0.0000	10 5		
					7/]	17460		(VIO)	H 4104106
AN3C4A	Purchased	No		255	Each	2,162.000	10	10	
BOLT								Il u	00/06
			Location	Loc	<u>Oty</u>	Loc Code			
			ST350		2162				_
			117313		2				
			117688 117795		776				_
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			118012		500			-	<u>_</u> `
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W/O:	•	WORK ORDER CHANGES										
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Picklist Print

Tuesday, June 28, 2011 10:15:05 AM

Page 3

Work Order ID: 71329

Parent Item:

D3391-021

Parent Item Name: Fwd Tube Assembly



Start Date: 6/28/2011

Required Date: 7/27/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Phenolic Washer

AELS-1032-130

INSERT AELS-1032-225

INSERT

Manufactured No 255

Each

1,122.000

1107106

		Location	<u>Lo</u>	c Oty	Loc Code				
		ST074		1096					
		64177 66821		596		X	<u>J</u>		
		50821 ST077		500					
		52505		26 26					
Purchased	No		255	Each	0.0000	2 2			
				W 11=	7717	(x2) jll	11/07/06	
Purchased	No		255	Each	0.0000	10 1	0		
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		esolution:	Dispositi	on:	QA: N/C	Clos	sed:		Date: _	
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DATE	STEP	Description of NC Corrective Actio			ection B		Verific	cation	Approval	Approval
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DART AEROSPACE LTD	Work Order:	41329
Description: Float Skidtube (412)	Part Number:	D3391-1
Inspection Dwg: D3391 Rev: H		Page 1 of 1

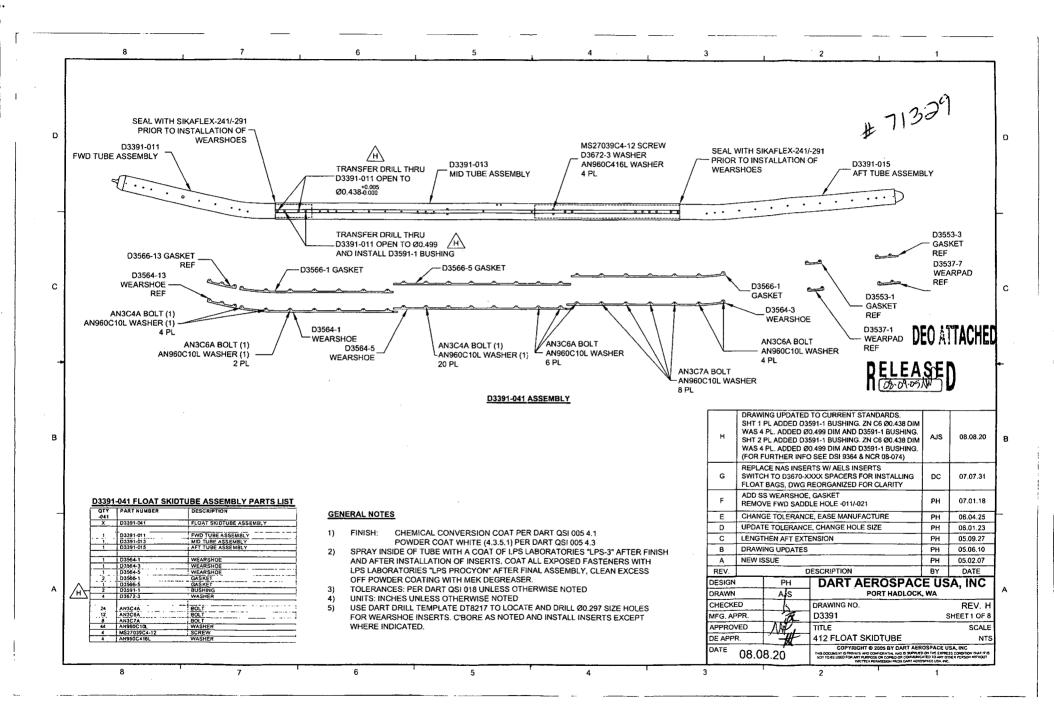
FIRST ARTICLE INSPECTION CHECKLIST

. Into I retired a little and a										
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments				
0.687	+0.010/-0.000	0.692	~		Vein	6A-01				
3.590	+0.025/-0.010	3,612	~		Mic	GA-10				
3.300	+0.040/-0.000	3.324	~		Vern	GA-01				
1.429	+0.040/-0.060	1.423	1		} ₁	11				
4.250	+/-0.010	4.252			17	(1				
4.250	+/-0.010	4.250	/	1	11	11				
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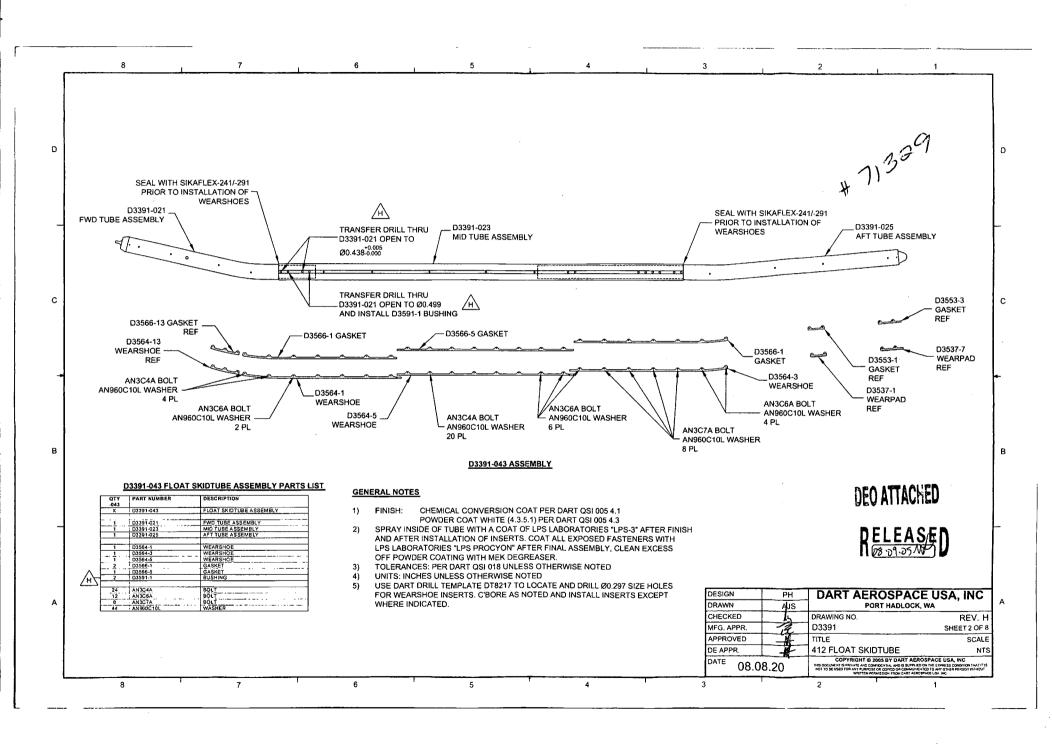
Measured by:	BARO	Audited by:	Col	Preliminary Approval:	
Date:	11/06/29 11/0	Date:	11/56 29	Date:	

Date	Change	Revised by	Approved
06.04.27	New Issue P/O D3391-011/-021	KJ/JLM	
06.06.19	Tolerances revised per D3391 Rev. E	KJ/JLM	
07.03.21	Dimensions removed per Dwg rev. F	KJ/JLM	
07.11.23	Dwg Rev. updated	KJ/EC/DD	
09.12.14	Dwg Rev updated	KJ 🕠	/////
11.06.21	Dimension 0.500 added	KJ 💔	CZMI
	06.04.27 06.06.19 07.03.21 07.11.23 09.12.14	06.04.27 New Issue P/O D3391-011/-021 06.06.19 Tolerances revised per D3391 Rev. E 07.03.21 Dimensions removed per Dwg rev. F 07.11.23 Dwg Rev. updated 09.12.14 Dwg Rev updated	06.04.27 New Issue P/O D3391-011/-021 KJ/JLM 06.06.19 Tolerances revised per D3391 Rev. E KJ/JLM 07.03.21 Dimensions removed per Dwg rev. F KJ/JLM 07.11.23 Dwg Rev. updated KJ/EC/DD 09.12.14 Dwg Rev updated KJ

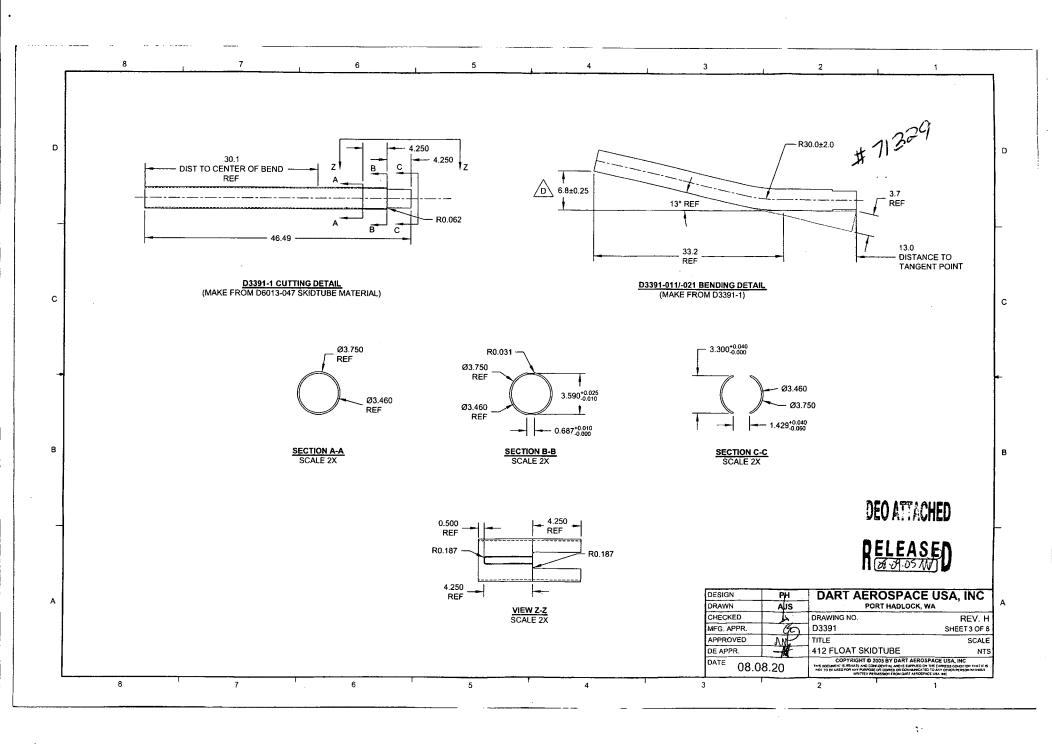




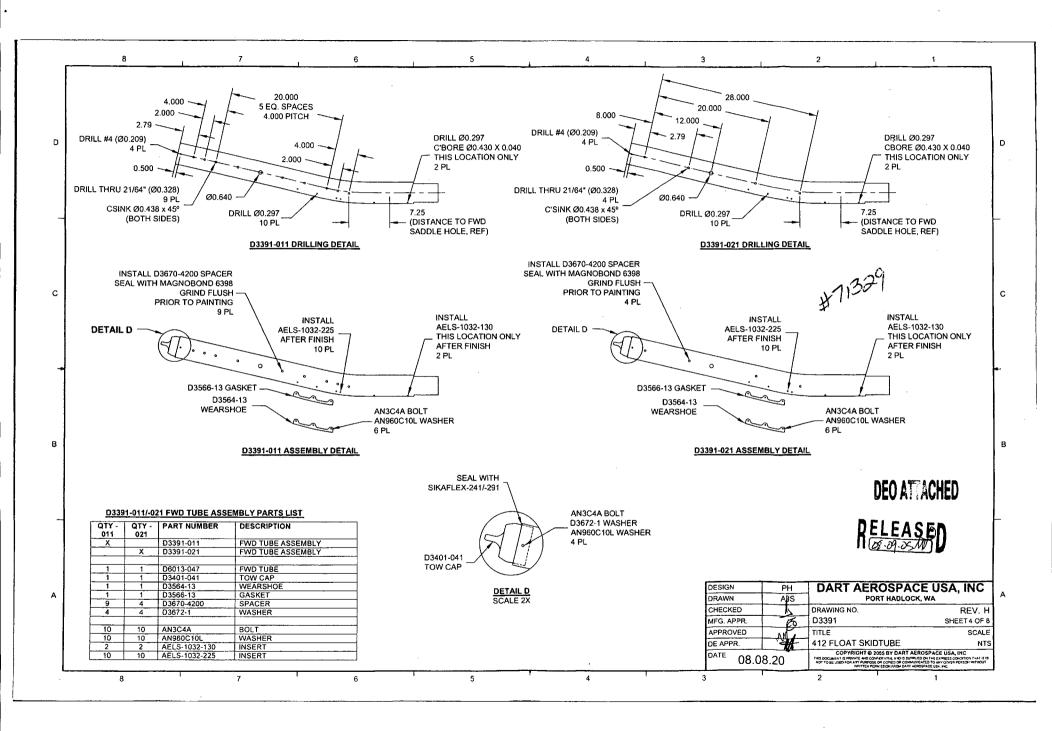
W/O:			W	ORK ORDER CHANGE	ES				
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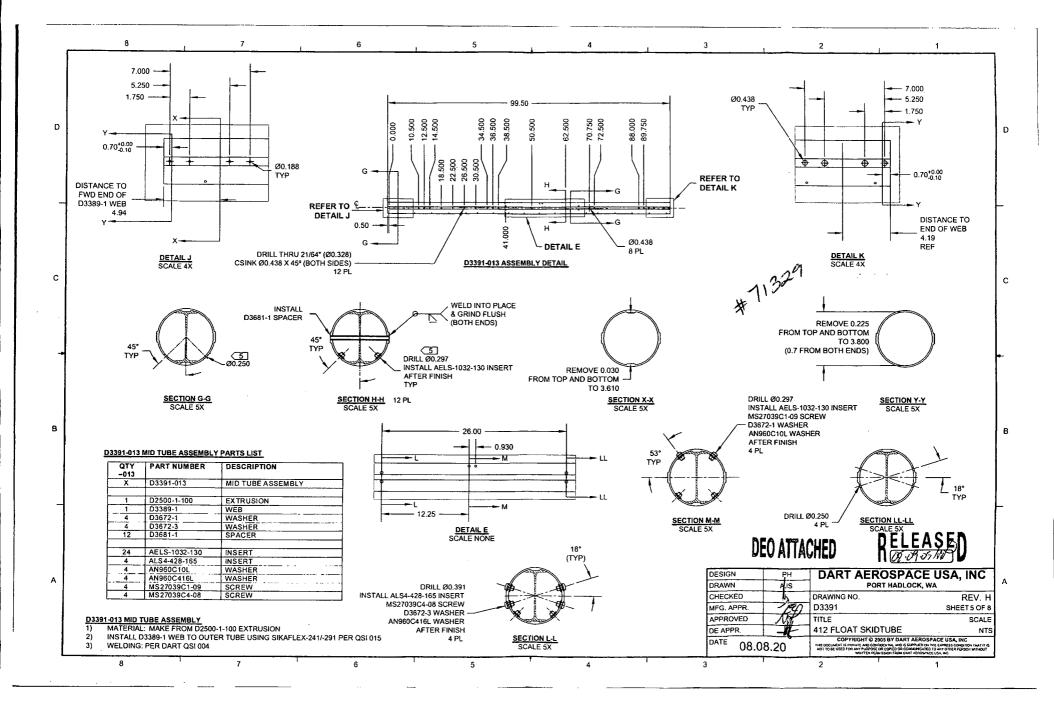
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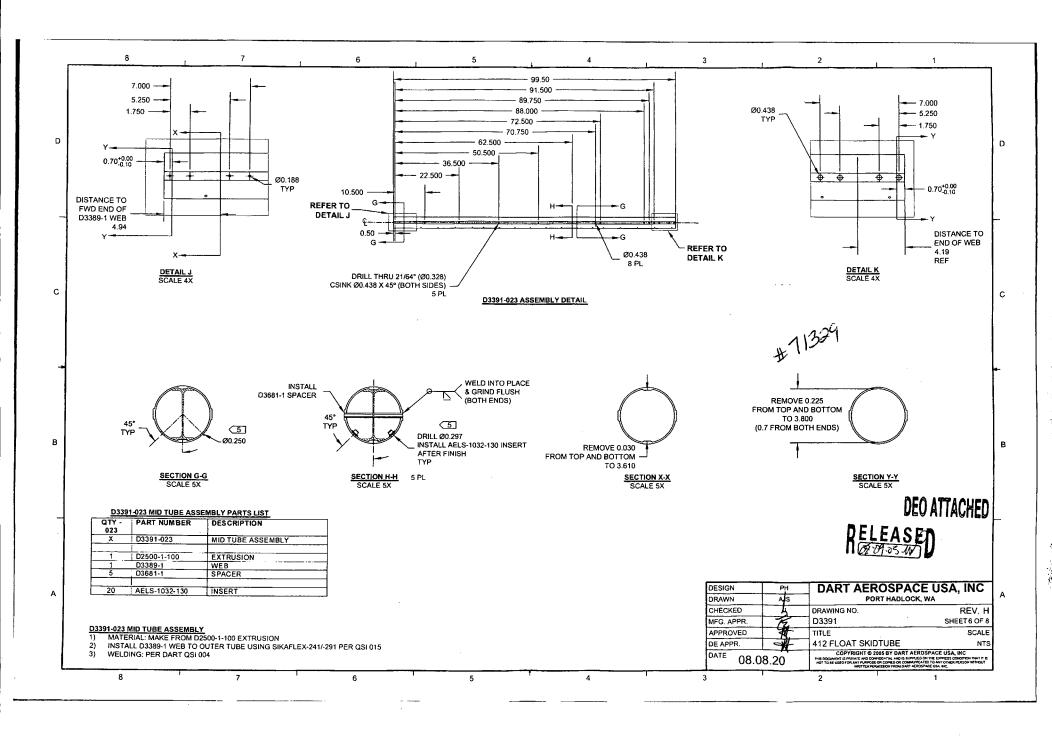
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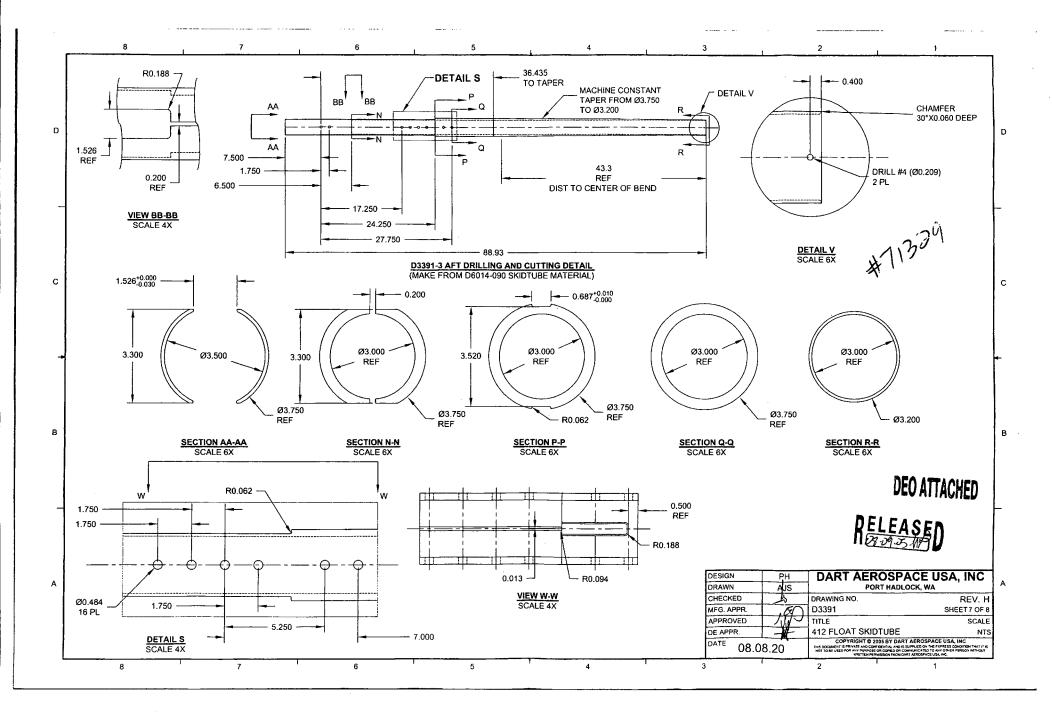
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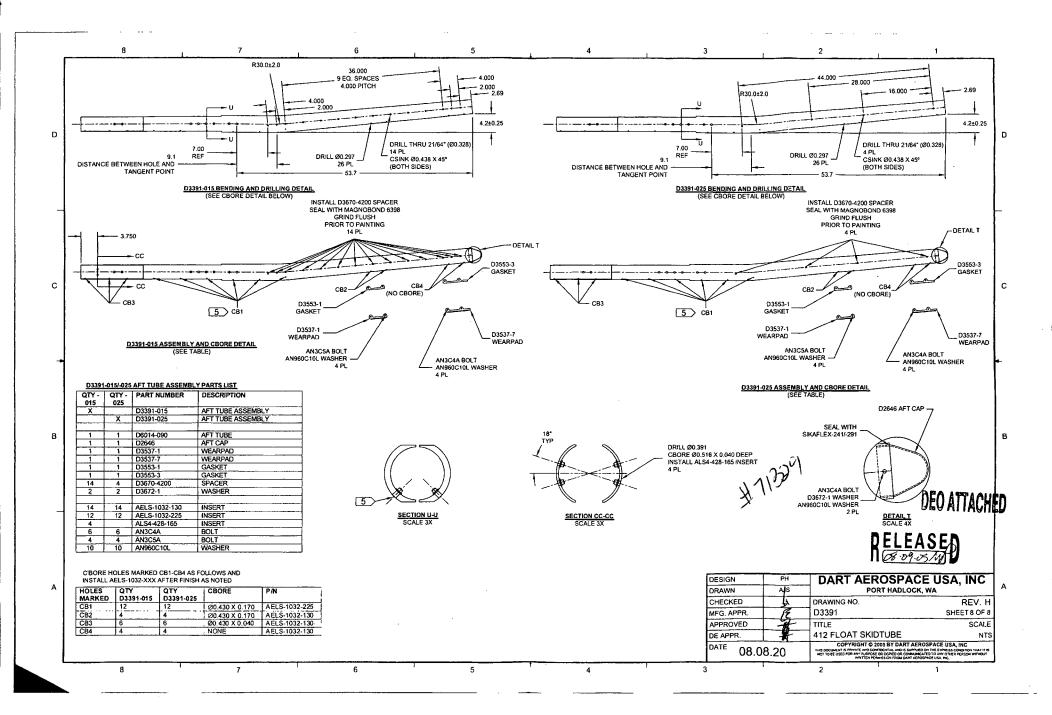
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DRAWING NO.		TITLE		REV. H	DART AEROS	SPACE USA, II	NC D.E.O. NO.		SHE	ET NO.	SCAL	Ε
D3391		412 FLOAT	SKIDTUBE	1	ENGINEE	RING ORDER	D3391-H-1		SHEE	T 1 OF, 1	N ⁻	TS
DRAWN	(1)		CHECKED	<u>l</u>	MFG. APPR.	Ŋ	APPROVED /	W	DE APPR.	-10>		
DATE 09	.09.2	23	DATE	04.04.24	DATE 09	109125	DATE 09/0	9/30	DATE	09/09	30	

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH-AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.



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